

SPWIT-

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLUG
Job Number	: 32466		
Estimate Number	: 10512		
P.O. Number	: N/A	Part Number	: D26511
This Issue	: 5/23/2007 S.O. No. : N/A	Drawing Number	: D2651 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 32118	Material	: N/A
Written By	: [Signature]	Due Date	: 6/6/2007 Qty: 200 Lm: Each
Checked & Approved By	: [Signature] 07.05.24		
Comment	: Est. A 92.04.15 New Issue NG		
	: Est. B 05.12.12 added deburr EC		

Additional Product

Seq. #:	Machine Or Operation:	Description :
10	M6061T6R0500	6061-T6 Round Bar 500"
Comment: Qty.: 0.0421 f(s)/Unit Total: 8.4210 f(s) <i>M104619 81" [7.25]</i> Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <i>M103961 28" [2.3]</i> <i>RQ on file</i>		
20	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HAAS CNC VERTICAL MACHINING #1 <i>Hardinge cnc lathe</i> 1- Turn as per Folio FA219 and Dwg D2651 2- Deburr <i>RQ MS on file</i>		
30	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>x 220</i> <i>RQ MS on file</i>		
40	QC8	SECOND CHECK
Comment: SECOND CHECK <i>Sc on file</i>		
50	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr ias per dwg D2651 <i>ml</i>		

Date: Wednesday, 5/23/2007 3:24:23 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 32486

Part Number: D26511

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(44X)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.L.

07/06/27

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3
(Only larger section necessary)

Spray paint
Self flat Blue + clear

issue P.O. 4058 (26/06/27)
Atelier de base/age

(44)

44

8.0

QC14

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

20.07.03

counted (45)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location:

Final stock (27/7/7) (42)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(45)

Comment: FINAL INSPECTION/W/O RELEASE

20/07/04

Job Completion



12 07.07.04

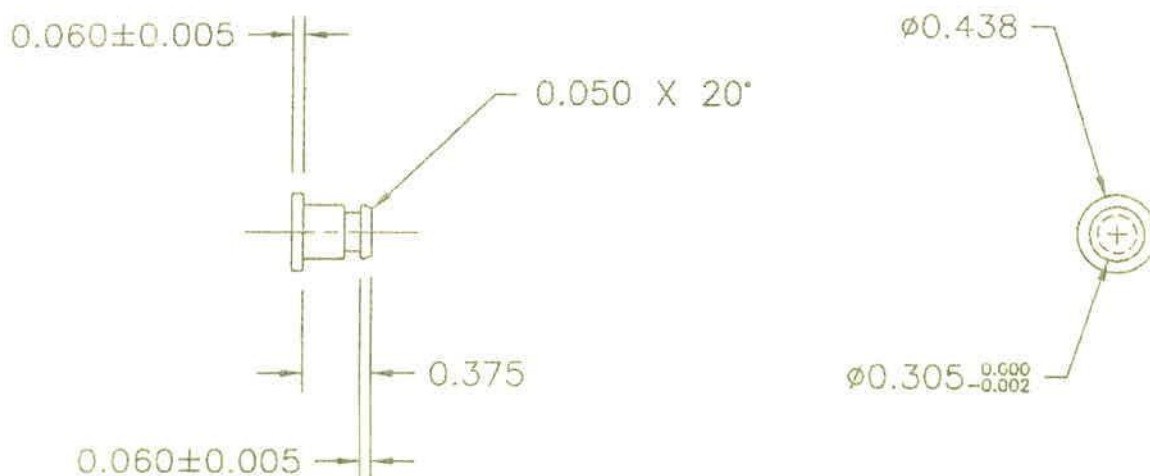


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

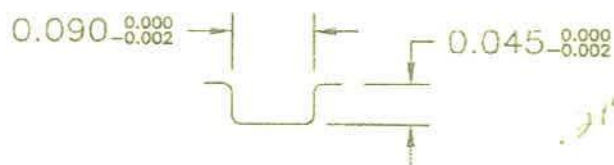
RELEASED

03.12.19

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16 ID, 5/16 OD, 1/16 WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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